

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003134**Date Inspected:** 21-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

**Bay 3 –Tower Heavy Machinery Shop**

The QA Inspector observed ZPMC qualified welder Dong Yi Qun ID 059450 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP78-001.

The QA Inspector observed four ZPMC personnel performing grinding of deck panel DP080-001 for preparation to perform weld repairs.

The QA Inspector observed that ZPMC was in the process of removing deck panel DP028-001 from the shop to be transported to the Assembly Shop.

The QA Inspector observed ZPMC CWI Inspector was present, one ZPMC personnel was performing preheat of areas to be welded, four ZPMC personnel performing grinding, and two ABF QA personnel identified as Kevin Chen and Ding Baohua were monitoring the welding.

The deck panel repair welding in the progress generally appeared to conform to contract specifications.

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## WELDING INSPECTION REPORT

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The QA Inspector located and inventoried the following 30 deck panels in New Tower Building Bay #3 on this date: DP026-002,DP067-002,DP055-001,DP052-001,DP003-001,DP042-001,DP038-001,DP077-001,DP065-001, DP015-001,DP074-001,DP025-001,DP020-001,DP030-002,DP042-001,DP040-001,DP006-001,DP051-001, DP050-001,DP049-001,DP078-001,DP075-001,DP080-001,DP027-001,DP070-001,DP072-001,DP031-001, DP018-001,DP030-001, and DP071-001.

For more detail see photograph shown below:



### Summary of Conversations:

As noted within the report shown above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dixon,Roscoe	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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